

A 13

Work Order ID 108043

October-07-13 9:07:13 AM

108043

Page 1

Item ID: D4000-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fuel Pickup Fitting

Stop

NS2

Start Date: 10/07/13 Start Qty: 14.00

14

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-10-08 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4000	A	0.00							
100 *100* Doosan Doosan Lathe	Memo Turn as per DWG and Folio Fa905 Folio Rev: AA Dwg Rev: A ***USE DIE TO TEST THEADS ON PARTS***	0.00	DAS 40 9-83	13/11/22	14	Ø			
110 *110* QC Quality Control	Deburr, QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	DAS 40 9-83	13/11/22	14	Ø			

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
				Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data	<input type="checkbox"/>											
Equip/Tooling	<input type="checkbox"/>											
Operator	<input type="checkbox"/>											
Material	<input type="checkbox"/>											
Setup	<input type="checkbox"/>											
Other	<input type="checkbox"/>											
Process	<input type="checkbox"/>											
Supplier	<input type="checkbox"/>											
Training	<input type="checkbox"/>											
Unapproved	<input type="checkbox"/>											
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube					General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other	

Work Order ID 108043

October-07-13 9:07:13 AM

108043

Page 2

Item ID: D4000-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Pickup Fitting

Start Date: 10/07/13 **Start Qty:** 14.00

14

Cust Item ID:

Required Date: 10/07/13 **Req'd Qty:** 14.00

14

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

13/11/24

120

QC

Quality Control

0.00

130

Identify as per dwg & Stock Location: W1003 0.00

DAS

26

9-89

130

Packaging

Packaging

Memo

0.00

14A

13-11-25

140

QC21- Final Inspection - Work Order Release

0.00

13/11/27 80

140

QC

Quality Control

Memo

0.00

MF
13-11-25

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

Picklist Print

October-07-13 9:07:13 AM

Page 1

Work Order ID: 108043

Parent Item: D4000-7

Parent Item Name: Fuel Pickup Fitting

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 14.00

Required Qty: 14.00

Comments: lpp Rev:A New Issue 10-01-28 JLM Verified By:EC IPP rev B 10.05.13 ecn10-562 EC
verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6RL500 6061-T6 Round Bar 1.50		Purchased	No			100	f	8.9260	0.131	1.834		DAS 13/11/22 40 9-89	

Location	Loc Qty	Loc Code
MAT013	8.926	
110167	3.954	
123483	4.972	

→ M127464

2.25

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

DART AEROSPACE LTD	Work Order:	108043
Description: Fuel Pickup Fitting	Part Number:	D4000-7
Inspection Dwg: D4000 Rev: A		Page 1 of 1

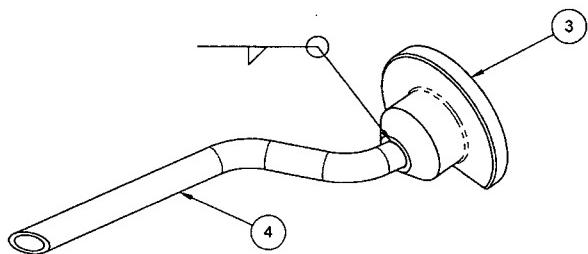
FIRST ARTICLE INSPECTION CHECKLIST

10

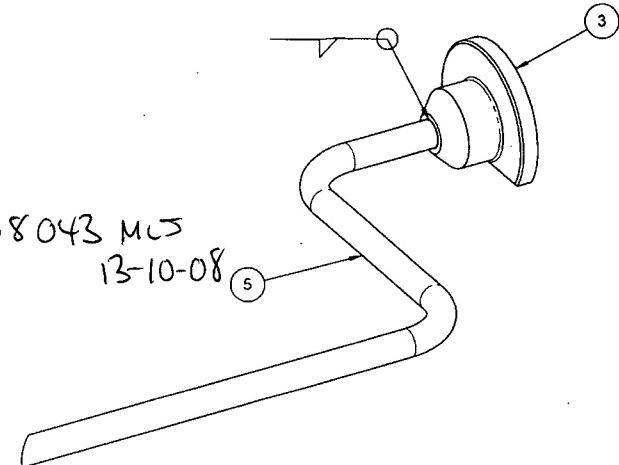
Measured by:	40 9-89	Audited by:	<i>Am</i>	Preliminary Approval:	N/A
Date:	13/11/22	Date:	13/11/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ	
B	11.01.17	Dimensions revised	KJ	

ITEM	QTY. -043	QTY. -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
2		X	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
3	1	1	D4000-3	FUEL SUMP DRAIN FITTING	
4	1		D4003-1	INTERNAL DRAIN LINE, AFT	
5		1	D4003-3	INTERNAL DRAIN LINE, FWD	



D4000-041 DRAIN FITTING ASSEMBLY, AFT



D4000-043 DRAIN FITTING ASSEMBLY, FWD

- A NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043-045" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D4000-043 - 0.04 lbs
D4000-045 - 0.05 lbs

A	NEW ISSUE	REV.	DATE
			10.02.10
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
SHEET 1 OF 8

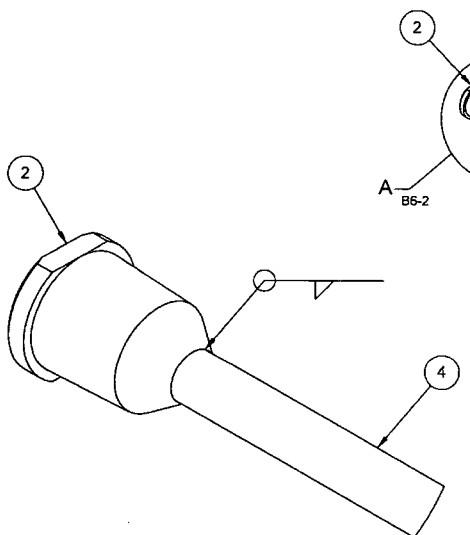
DRAWING NO.
D4000

TITLE
FITTING

SCALE
NTS

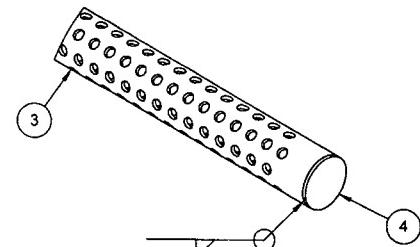
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ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
2	1	D4000-7	FUEL PICK UP FITTING	
3	1	D4000-11	CAP	
4	1	D4003-5	FUEL PICK UP LINE	



DETAIL A
SCALE 4X C6-2

D4000-045 FUEL PICKUP FITTING ASSEMBLY



DETAIL B
SCALE 4X B2-2

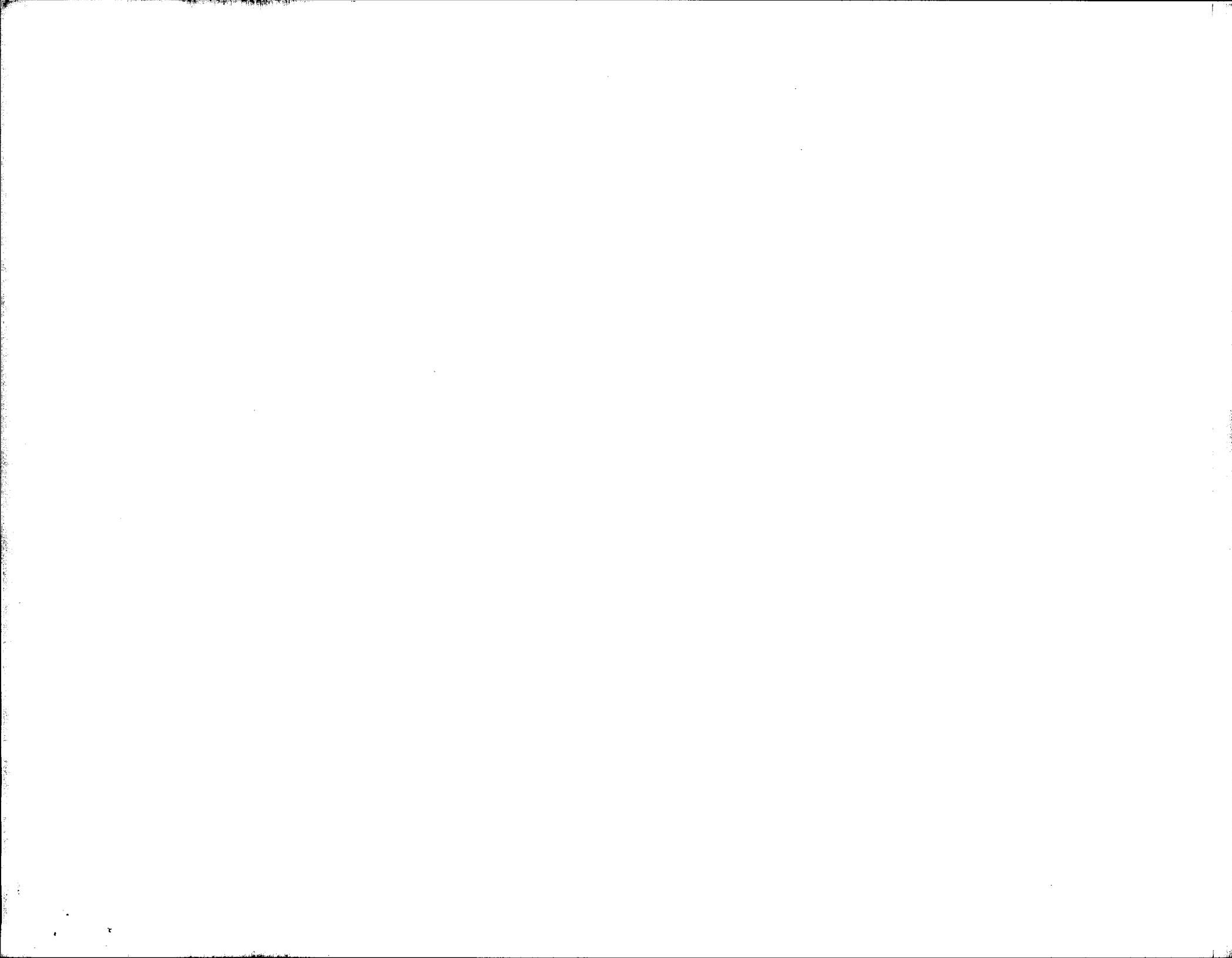
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		DRAWING NO. REV. A
APPROVED		D4000 SHEET 2 OF 8
DE APPR.		TITLE SCALE
DATE	10.02.10	NTS

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RELEASED
2010-05-05
[Signature]



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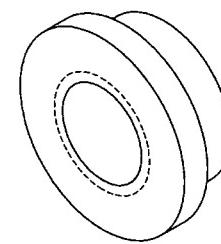
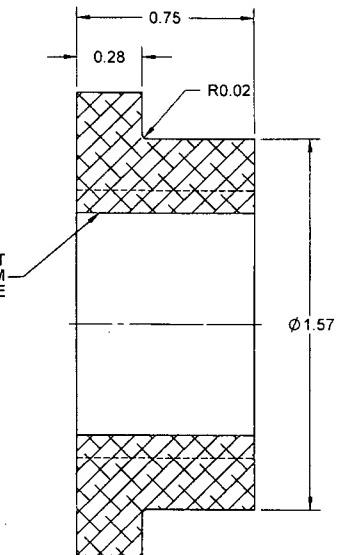
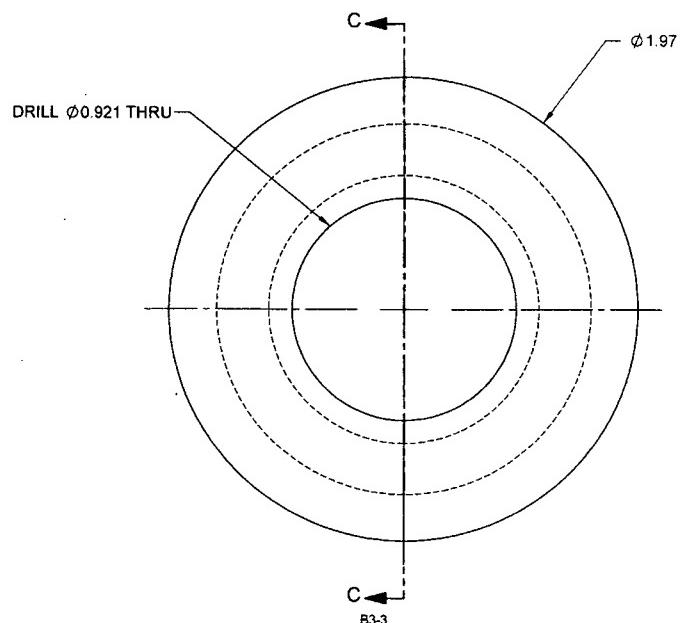
3

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108043

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-1	JCA-M47-1-04



D4000-1 FUEL SUPPLY FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4000
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 8
DATE 10.02.10		SCALE
		NTS
FITTING		
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8 7 6 5 4 3 2 1



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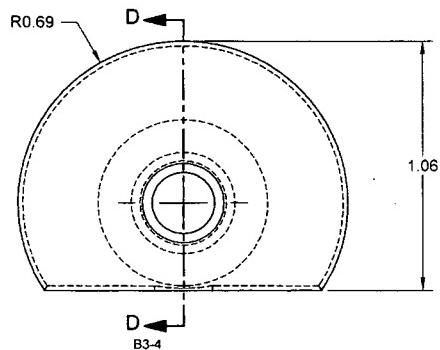
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108043

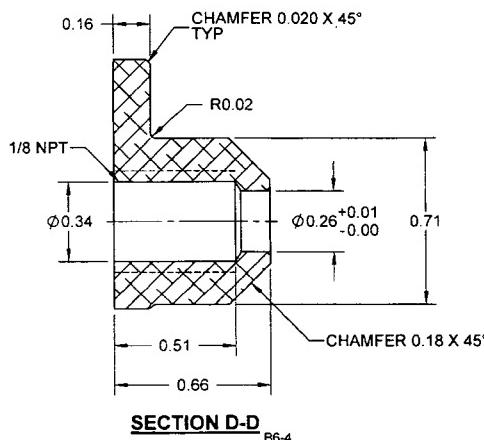
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-3	JCA-M47-1-05

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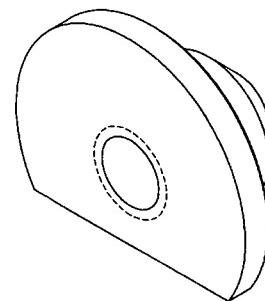


B

C



SECTION D-D B6-4



D

C

B

A

D4000-3 FUEL SUMP DRAIN FITTING

RELEASED
2010-05-05
[Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4000
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 4 OF 8
DATE 10.02.10		SCALE
		NTS
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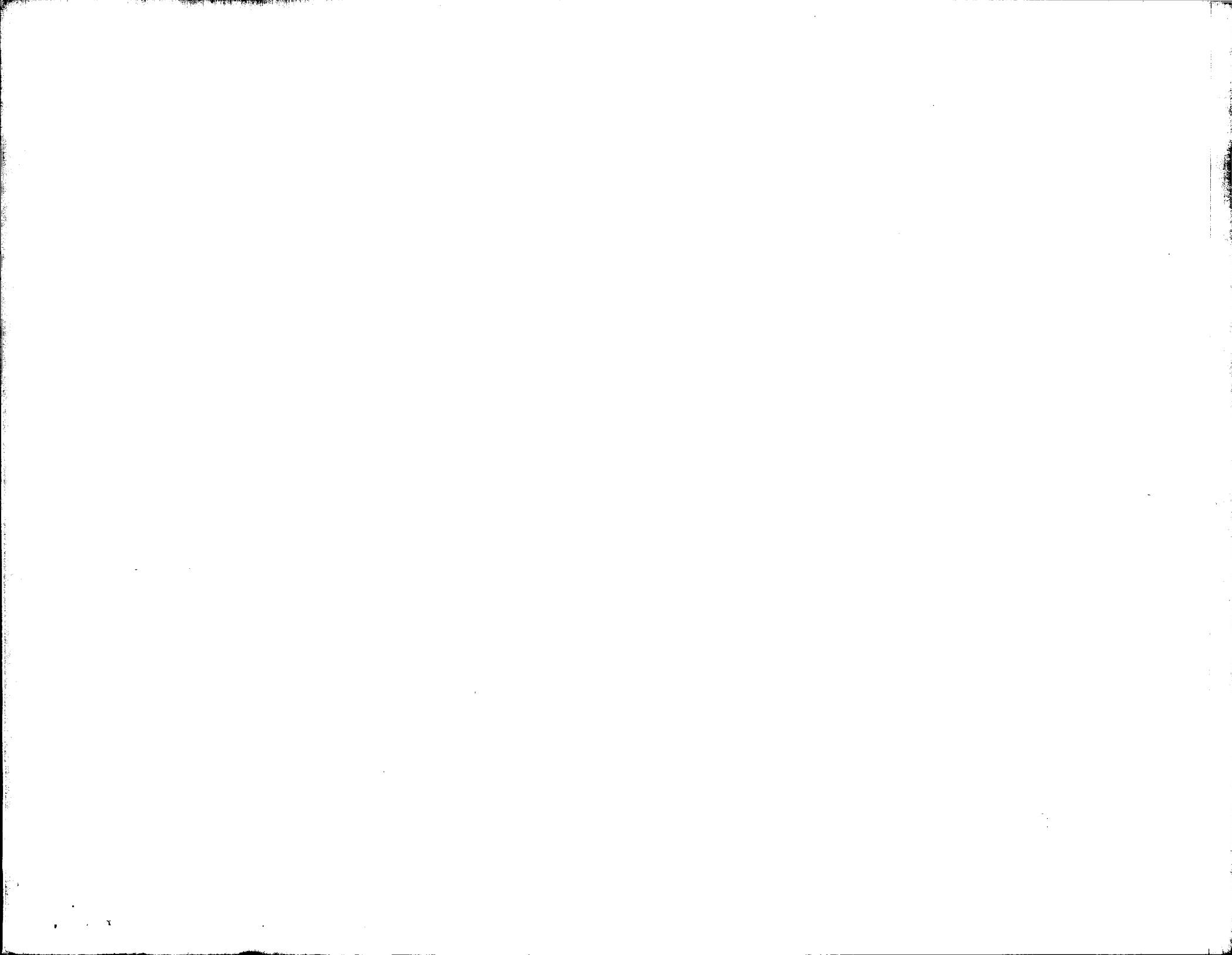
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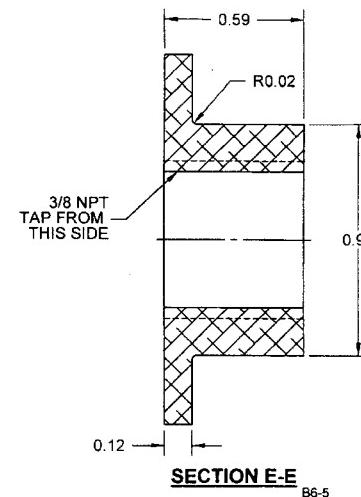
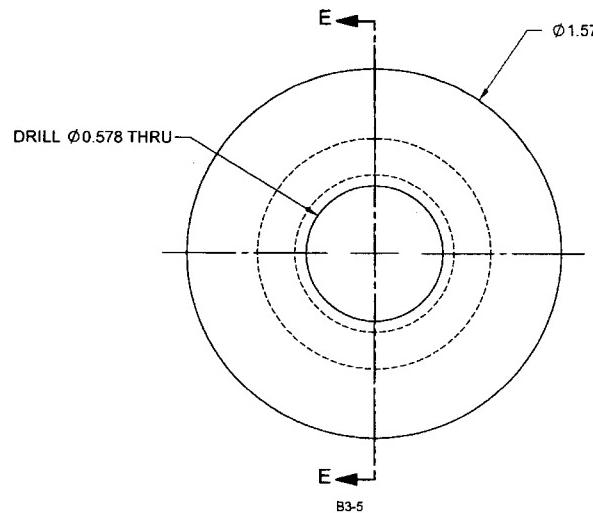
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10804B

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09



D4000-5 FUEL TANK VENT FITTING

NOTES:

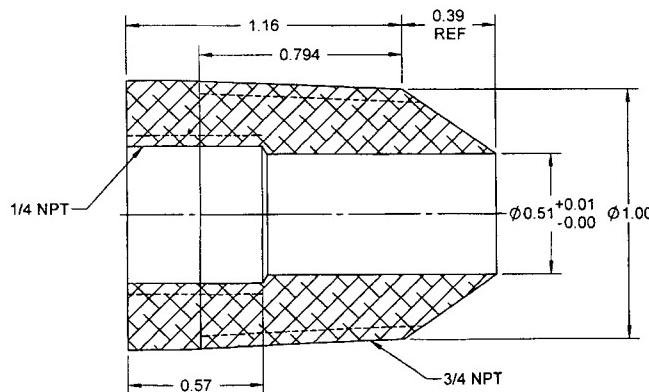
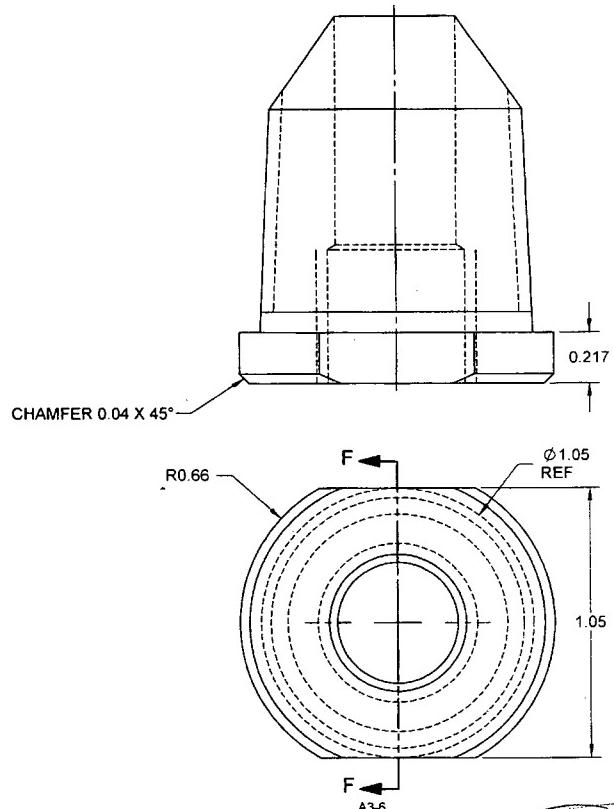
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

8 1 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4000
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 5 OF 8
DATE	10.02.10	SCALE
		NTS
FITTING		
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108043

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10

SECTION F-F
A6-6RELEASED
2010-05-05
MPD4000-7 FUEL PICK UP FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D4000
APPROVED		REV. A
DE APPR.		TITLE
DATE 10.02.10		SCALE
		NTS

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

D

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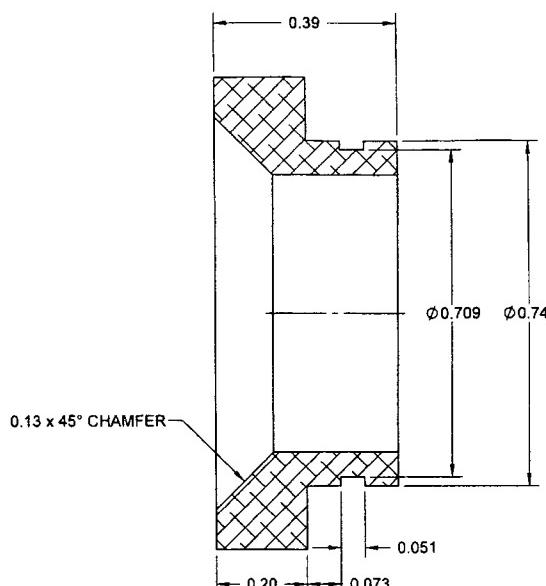
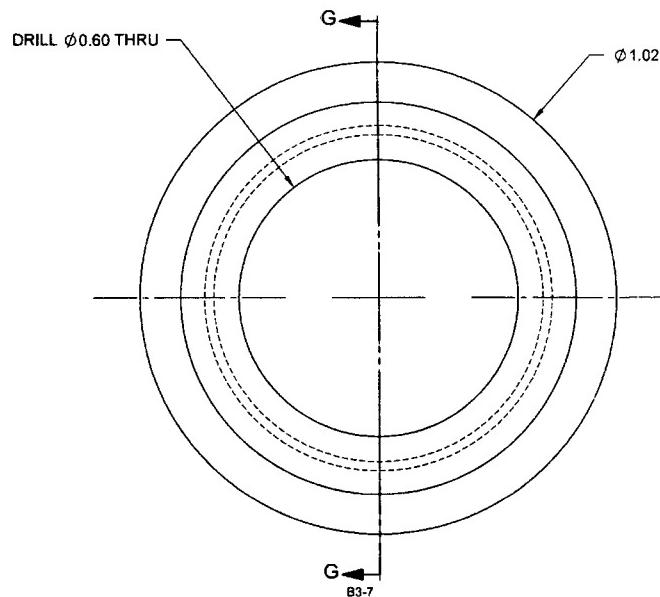
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D4000-9 GROMMET

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DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	10.02.10	

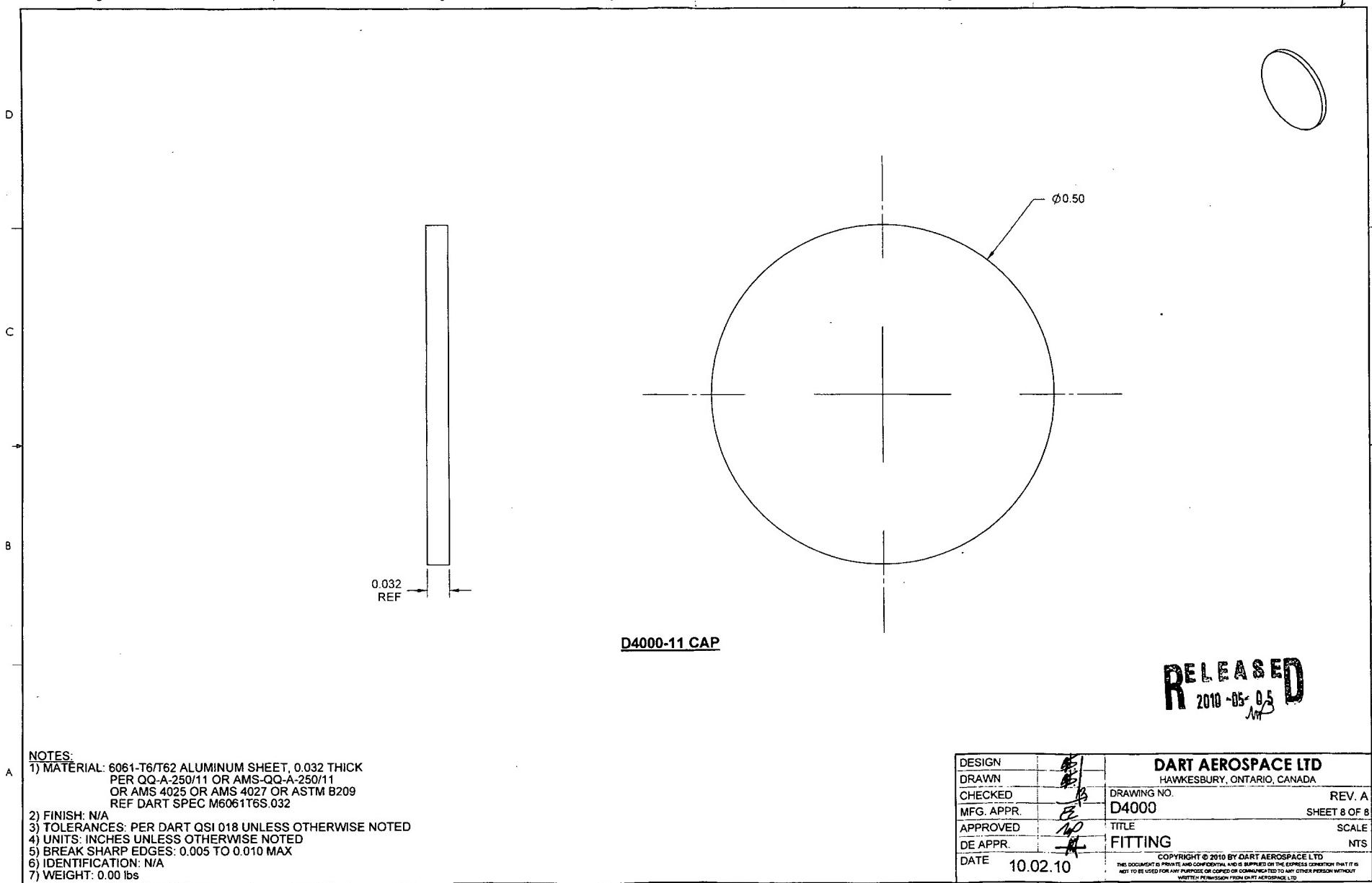
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NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø 1.000 ROUND BAR
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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DE APPR.		TITLE
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